












Date: Wednesday, 10/24/2007 3:34:55 PM
User: Jean-Luc Menard

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STEM
Job Number : 35364	
Estimate Number : 11107	
P.O. Number : N/A	Part Number : D34071
This Issue : 10/24/2007 S.O. No. : N/A	Drawing Number : D3407 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : C
Previous Run : 32898	Material : N/A
Written By : <u>JLM 07-10-24</u>	Due Date : 10/31/2007 Qty: 21 Um: 20 Each
Checked & Approved By : _____	
Comment : Est Rev: A 06.10.18 New issue KJ/EC	

Additional Product

Job Number:		
Seq. #:	Machine Or Operation:	Description :
1.0	M174R0750	Inventory
		
Comment: Qty.: 0.3843 f(s)/Unit Total : 7.6860 f(s) <u>9.37'</u> Material: 17-4ph SS Round Bar Ø0.750(M17-4-R0.750) Batch: <u>M105710</u> <u>29 07/10/26</u>		
2.0	HARDINGE	HARDINGE CNC LATHE SMALL
		
Comment: HARDINGE CNC LATHE SMALL 1-Turn as per Folio FA596 Rev: <u>C</u> & Dwg D3407 Rev: <u>C</u> 2-Deburr <u>29 07/10/26</u>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>29 07/10/26</u> <u>(21)</u>		
4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
		
Comment: HAAS CNC VERTICAL MACHINING #1 1- Machine as per Folio FA597 and Dwg D3407 2-Deburr <u>J.L 07/11/22</u>		
5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>J.L 07/11/22</u>		

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEM

Job Number: 35364

Part Number: D34071

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SD 07.11.22

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PATD

KS

(21)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



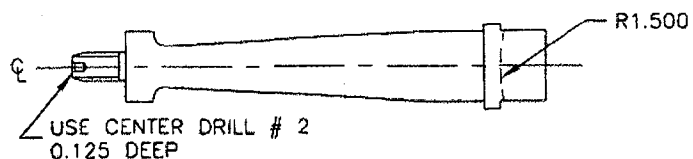
Comment: FINAL INSPECTION/W/O RELEASE

SD 07.11.26

Job Completion

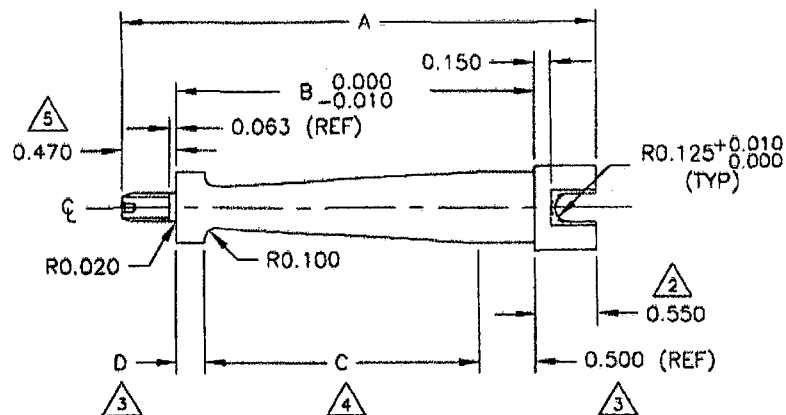


U 07.11.26



RELEASED

05.09.12



PART NUMBER	A	B	C	D
D3407-1	5.270	4.250	3.250	0.500
D3407-3	4.325	3.305	2.555	0.250

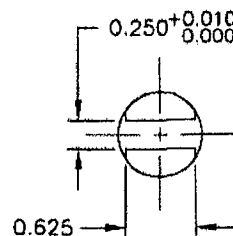
D3407-1/-3 STEM

D3407-1 AND D3407-3 STEM:

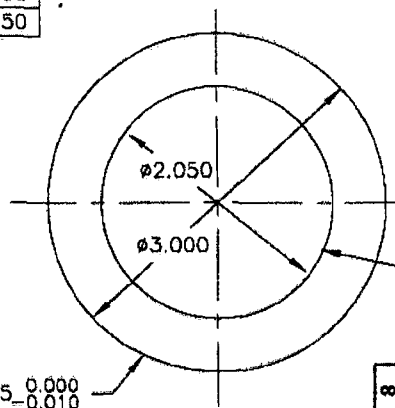
- 1) MATERIAL: 17-4 PH SS ROUND BAR (REF DART SPEC. M17-4-R0.750)
- 2) $\phi 0.750$ O.D.
- 3) $\phi 0.625$ O.D.
- 4) MACHINE UNIFORM TAPER FROM $\phi 0.363$ O.D. TO $\phi 0.625$ O.D.
- 5) 1/4-28 UNF THREAD WITH 0.063 GRIP, CLASS 2A
- 6) MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
- 7) UNLESS OTHERWISE INDICATED
- 8) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

D3407-5 RING:

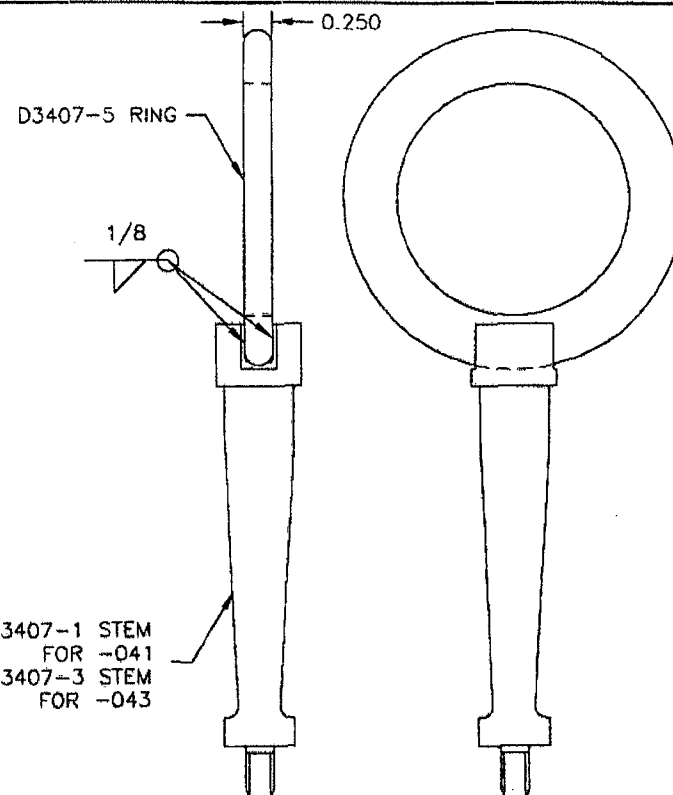
- 9) MATERIAL 17-4 PH SS ROUND BAR (REF DART SPEC. M17-4-R3.000)
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



USE D3407-1 STEM FOR -041
USE D3407-3 STEM FOR -043



D3407-5 RING



D3407-041 AND D3407-043 TOW RING:

- 11) WELD PER QSI 004 ON ALL EDGES BETWEEN STEM AND RING
- 12) FINISH: POWDER COAT WHITE (REF 4.3.5.2) PER DART QSI 005 4.3 (EXCEPT THREADS)
- 14) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DEBURR 0.010 TO 0.020

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C	05.09.09	-1/-3 LONGER FOR FIT W/ WASHER
B	05.06.17	UPDATE DIAMETER, THREAD CLASS ADDED
A	05.03.16	NEW ISSUE
DESIGN	CP	DRAWN BY CP
CHECKED	TH	APPROVED CH
DATE	05.09.09	TOW RING
DRAWING NO.	D3407	REV. 2
TITLE	TOW RING	SHEET 1 OF 1
SCALE		1:1

DART DART AEROSPACE USA, INC.
PORT HADLOCK, MA

DART AEROSPACE LTD		Work Order:	
Description: Tow Ring		Part Number:	D3407-1
Inspection Dwg: D3407 Rev: C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
5.270	+/-0.010	5.265	✓			
4.250	+0.000/-0.010	4.245	✓			
3.250	+/-0.010	3.250	✓			
0.500	+/-0.010	.498	✓			
0.500	+/-0.010	.500	✓			
0.470	+/-0.010	.470	✓			
Ø0.625	+/-0.010	.625	✓			
Ø0.750	+/-0.010	.748	✓			
Ø0.625	+/-0.010	.622	✓			
Ø0.363	+/-0.010	.363	✓			
0.063 Ref	+/-0.010	.063	✓			
R0.020	+/-0.010	R.015	✓			
0.550	+/-0.010	.553	✓			
0.625	+/-0.010	.625	✓			
0.250	+0.010/-0.000	.251	✓			
0.150	+/-0.010	.144	✓			
MOW = 0.266	+/-0.001	.265	✓			

Measured by: RCP / J.L.	Audited by: SA	Prototype Approval:	N/A
Date: 07/10/22	Date: 07/11/22	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.09.19	New Issue	KJ/JLM	
B	07.07.18	Tolerances for diameters updated per Machinists	KJ/JLM	B